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(54) **SEMICONDUCTOR DEVICE AND METHOD OF MANUFACTURING THE SAME**

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257/E23.005–E23.009, E23.041,
257/E23.053–E23.055

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See application file for complete search history.

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(30) **Foreign Application Priority Data**

Sep. 25, 2013 (JP) 2013-198812

(57) **ABSTRACT**

There is provided a semiconductor device having a converter circuit, a brake circuit and an inverter circuit and manufacturable by a simplified manufacturing process. The semiconductor device has a plurality of die pads, IGBTs, diodes, freewheel diodes, an HVIC and LVICs mounted on the plurality of die pads, a plurality of leads, and an encapsulation resin body that covers these component parts. In a manufacturing process, a single-plate lead frame having the above-described plurality of die pads and leads connected together can be prepared. The semiconductor device may be manufactured by using this single-plate lead frame.

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H01L 23/495 (2006.01)

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CPC **H01L 24/85** (2013.01); **H01L 23/49575** (2013.01); **H01L 24/83** (2013.01); **H01L 2924/14** (2013.01); **H01L 2924/37** (2013.01)

(58) **Field of Classification Search**
CPC H01L 23/49503; H01L 23/4951;
H01L 23/49575; H01L 24/85; H01L 2924/14

1 Claim, 3 Drawing Sheets

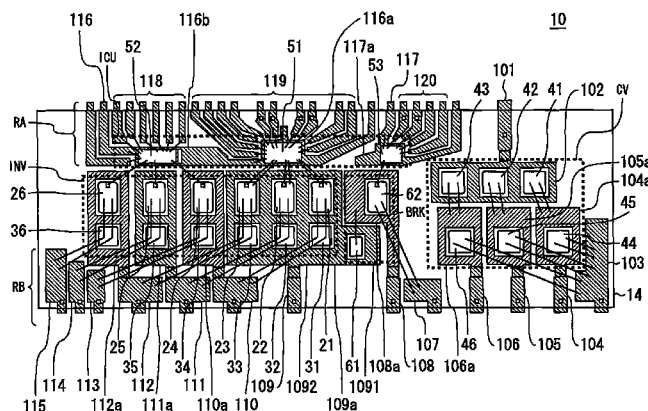


Fig. 2

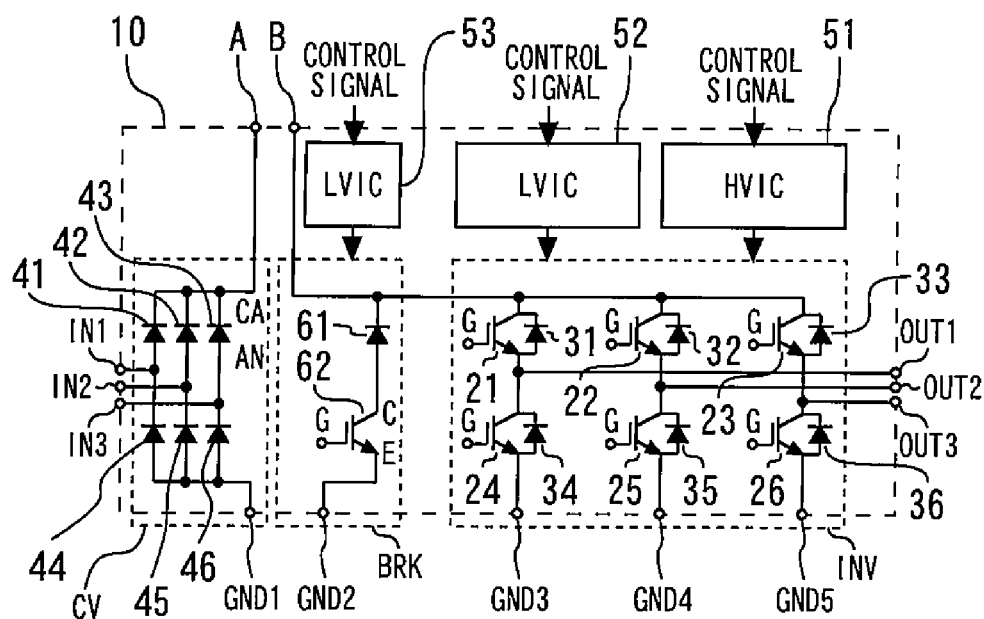


Fig. 3

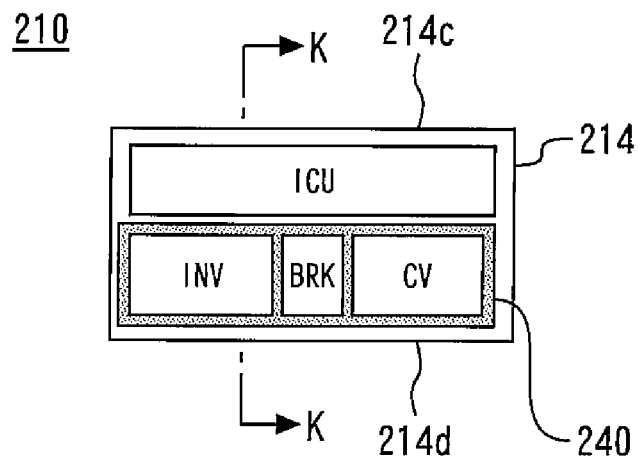


Fig. 4A

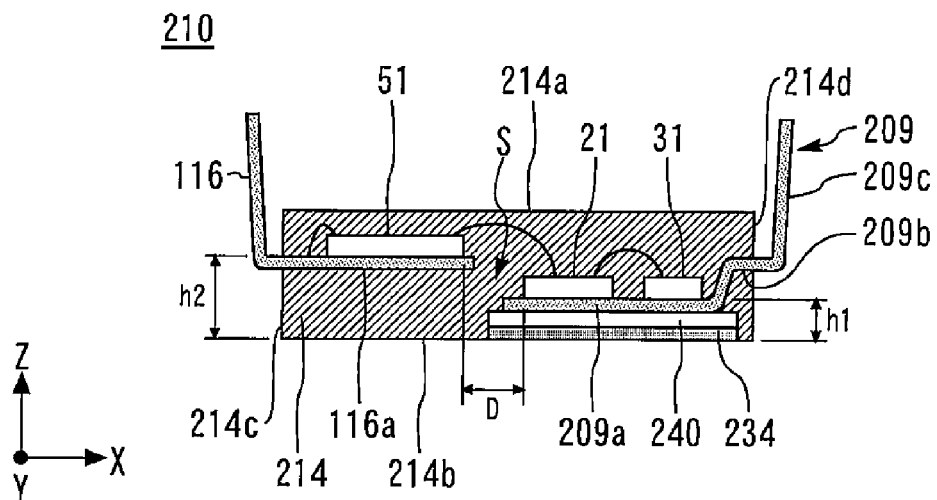
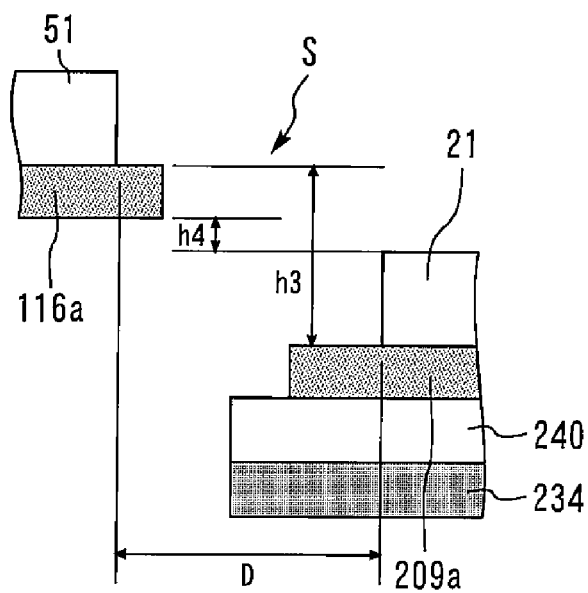


Fig. 4B



1

SEMICONDUCTOR DEVICE AND METHOD OF MANUFACTURING THE SAME

CROSS-REFERENCE TO A RELATED APPLICATION

The present application is a divisional of U.S. patent application Ser. No. 14/246,448, filed Apr. 7, 2014, which claims priority from Japanese Patent Application No. 2013-198812, filed Sep. 25, 2013, the entire contents of which all are incorporated herein by reference.

BACKGROUND OF THE INVENTION

1. Field of the Invention

The present invention relates to a semiconductor device and method for manufacturing the same.

2. Background Art

A semiconductor device is known which has circuits for inverter drive integrated into one package, as described in Japanese Patent laid-Open No. 2012-256803 for example. More specifically, a power module having a converter circuit, a brake circuit, an inverter circuit and a control circuit board for driving and controlling these circuits housed in one package has been proposed. A module having a converter circuit, a brake circuit and an inverter circuit integrated into one device is generally called a CIB power module.

Other prior art includes Japanese Laid-Open Patent Publication No. 2008-277433.

The semiconductor device according to the related art described above uses a lead frame and a control circuit board in combination. That is, power semiconductor elements are die-bonded on the lead frame and an integrated control circuit is mounted on the control circuit board. The control circuit board referred to herein represents various well-known control circuit boards having a circuit pattern provided on an insulating circuit board so that an integrated control circuit can be mounted. Use of a lead frame and a control circuit board in combination as in the above-described conventional semiconductor device necessitates an assembly process in which both the control circuit board and the lead frame are handled, thereby making the manufacturing process complicated.

SUMMARY OF THE INVENTION

The present invention has been made to solve the above-described problem and an object of the present invention is to provide a semiconductor device having a converter circuit, a brake circuit and an inverter circuit and manufacturable by a simplified manufacturing process.

According to one aspect of the present invention, a semiconductor device includes: a plurality of die pads; an inverter circuit element, a converter circuit element, a brake circuit element, and an integrated circuit mounted on the plurality of die pads; a plurality of leads; and an encapsulation resin body. The plurality of leads are respectively connected via wires to the inverter circuit element, the converter circuit element, the brake circuit element, and the integrated circuit. The encapsulation resin body covers one end portions of the plurality of leads, the inverter circuit element, the converter circuit element, the brake circuit element and the integrated circuit, and the encapsulation resin body does not cover other end portions of the plurality of leads.

Other and further objects, features and advantages of the invention will appear more fully from the following description.

2

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a top view showing a semiconductor device according to a first embodiment of the present invention.

FIG. 2 is a circuit diagram of the semiconductor device according to the first embodiment of the present invention.

FIG. 3 is a top view showing a semiconductor device according to a second embodiment of the present invention.

FIG. 4A is a sectional view of the semiconductor device according to the second embodiment of the present invention, taken along line K-K in FIG. 3, and FIG. 4B is an enlarged sectional view for explanation of the step height.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

First Embodiment

FIG. 1 is a top view showing a semiconductor device 10 according to a first embodiment of the present invention. The semiconductor device 10 has CIB circuit elements die-bonded on a plurality of die pads described later and wire-bonded on leads. The CIB circuit elements referred to herein are circuit elements of a converter inverter brake circuit (CIB circuit).

(Die Pads and CIB Circuit Elements)

The semiconductor device 10 incorporates a converter circuit section CV, a brake circuit section BRK, an inverter circuit section INV and an integrated control circuit section ICU. As shown in FIG. 1, the converter circuit section CV, the brake circuit section BRK and the inverter circuit section INV are arranged in a row at one of opposite sides of the semiconductor device 10, while the integrated control circuit section ICU is provided at the other side of the semiconductor device 10. Each of the inverter circuit section INV and the brake circuit section BRK includes an insulated gate bipolar transistor (IGBT) as a circuit element.

The semiconductor device 10 has, in the converter circuit section CV, a die pad 102 and die pads 104a, 105a, and 106a for mounting converter circuit elements. Back electrodes of three diodes 41, 42, and 43 are die-bonded to the die pad 102. The die pad 102 is connected to a lead 101.

A back electrode of the diode 44 is die-bonded to the die pad 104a, a back electrode of the diode 45 to the die pads 105a, and a back electrode of the diode 46 to the die pads 106a. Front electrodes of the diodes 41, 42, and 43 are respectively wire-bonded to the die pads 104a, 105a, and 106a. These semiconductor elements are converter circuit elements in the present embodiment.

The semiconductor device 10 has, in the brake circuit section BRK, a die pad 108a and a die pad region 1091 for mounting a brake circuit element. The die pad region 1091 is a portion of a die pad 109a. A back electrode of an IGBT 62 is die-bonded to the die pad 108a, and a back electrode of a diode 61 is die-bonded to the die pad region 1091. A front electrode of the diode 61 is wire-bonded to the die pad 108a. These semiconductor elements are brake circuit elements in the present embodiment.

The semiconductor device 10 has, in the inverter circuit section INV, die pad regions 1092, 110a, 111a, and 112a for mounting inverter circuit elements. The die pad region 1092 is the portion of the die pad 109a other than the die pad region 1091. Back electrodes of IGBTs 21, 22, and 23 and back electrodes of freewheel diodes 31, 32, and 33 are die-bonded to the die pad region 1092. These semiconductor elements are the inverter circuit elements in the present embodiment.

A front electrode of the IGBT **21** is wire-bonded to a front electrode of the freewheel diode **31**. A front electrode of the IGBT **22** is wire-bonded to a front electrode of the freewheel diode **32**. A front electrode of the IGBT **23** is wire-bonded to a front electrode of the freewheel diode **33**.

Back electrodes of an IGBT **24** and a freewheel diode **34** are die-bonded to the die pad **110a**. Back electrodes of an IGBT **25** and a freewheel diode **35** are die-bonded to the die pad **111a**. Back electrodes of an IGBT **26** and a freewheel diode **36** are die-bonded to the die pad **112a**.

A front electrode of the IGBT **24** is wire-bonded to a front electrode of the freewheel diode **34**. A front electrode of the IGBT **25** is wire-bonded to a front electrode of the freewheel diode **35**. A front electrode of the IGBT **26** is wire-bonded to a front electrode of the freewheel diode **36**.

The semiconductor device **10** has, in the integrated control circuit section ICU, die pads **116a** and **116b** and a die pad **117a**. The die pads **116a** and **116b** are integrated into a lead **116**. A high-withstand-voltage integrated circuit (HVIC) **51** is die-bonded to the die pad **116a**. A low-withstand-voltage integrated circuit (LVIC) **52** is die-bonded to the die pad **116b**. The die pad **117a** is a portion of a lead **117**. A low-withstand-voltage integrated circuit (LVIC) **53** is die-bonded to the die pad **117a**.

The IGBTs **21** to **26** and the freewheel diodes **31** to **36** provided as inverter circuit elements, the diodes **41** to **46** provided as converter circuit elements, the diode **61** and the IGBT **62** provided as brake circuit elements and the HVIC **51** and the LVICs **52** and **53** that are integrated circuits are mounted on the plurality of die pads enumerated above.

(Leads)

The semiconductor device **10** has a plurality of leads for electrical connection of the above-described CIB circuit elements and integrated circuits on the outside of the package.

The semiconductor device **10** has leads **101**, **103**, **104**, **105**, and **106** in the converter circuit section CV. The lead **101** is connected to the die pad **102**. The lead **103** is wire-bonded to front electrodes of the diodes **44**, **45**, and **46**. The lead **104** is connected to the die pad **104a**, the lead **105** to the die pad **105a**, and the lead **106** to the die pad **106a**.

The semiconductor device **10** has leads **107** and **108** in the brake circuit section BRK. The lead **107** is wire-bonded to a front electrode of the IGBT **62**. The lead **108** is connected to the die pad **108a**.

The semiconductor device **10** has leads **109**, **110**, **111**, **112**, **113**, **114**, and **115** in the inverter circuit section INV. The lead **109** is connected to the die pad **109a**. The lead **110** is connected to the die pad **110a** and wire-bonded to the front electrode of the freewheel diode **31**.

The lead **111** is connected to the die pad **111a** and wire-bonded to the front electrode of the freewheel diode **32**. The lead **112** is connected to the die pad **112a** and wire-bonded to the front electrode of the freewheel diode **33**.

The lead **113** is wire-bonded to the front electrode of the freewheel diode **34**. The lead **114** is wire-bonded to the front electrode of the freewheel diode **35**. The lead **115** is wire-bonded to the front electrode of the freewheel diode **36**.

The semiconductor device **10** has leads **116** and **117** and a plurality of leads **118**, a plurality of leads **119**, and a plurality of leads **120** in the integrated control circuit section ICU. The lead **116** is connected to the die pads **116a** and **116b** and integral with these die pads. The lead **117** is connected to the die pad **117a**.

The plurality of leads **118** are a plurality of leads arranged adjacent to the lead **116** and respectively wire-bonded to electrode terminals provided on a front surface of the LVIC **52**. The plurality of leads **119** are a plurality of leads arranged

adjacent to the plurality of leads **118** and respectively wire-bonded to electrode terminals provided on a front surface of the HVIC **51**. The plurality of leads **120** are a plurality of leads arranged adjacent to the lead **117** and respectively wire-bonded to electrode terminals provided on a front surface of the LVIC **53**.

The HVIC **51** is wire-bonded to control terminals (i.e., gate terminals) of the IGBTs **21**, **22**, and **23**. The LVIC **52** is wire-bonded to control terminals (i.e., gate terminals) of the IGBTs **24**, **25**, and **26**. The LVIC **53** is wire-bonded to a control terminal (i.e., a gate terminal) of the IGBT **62**.

Referring to FIG. 1, the plurality of leads provided in the semiconductor device **10** are divided into a lead group RA and a lead group RB. The lead group RA is a group of leads arranged along one of opposite sides of the package of the semiconductor device **10**. The lead group RA is formed by the leads **101**, and **116** to **120**. The lead group RB is a group of leads arranged along the other side of the package of the semiconductor device **10**. The lead group RB is formed by the leads **103** to **115**.

In a manufacturing process, a single-plate lead frame having the above-described plurality of die pads **102**, **104a** to **112a**, **116a**, **116b**, and **117a** and leads **101**, and **103** to **120** made of one metal material and connected together by an outer frame portion can be prepared. The semiconductor device **10** may be manufactured by using this single-plate lead frame and performing a mounting process, a resin-encapsulation process and an outer frame lead cutting process each known per se.

More specifically, referring to FIG. 1, each of long frame portions extending along opposite sides of an encapsulation resin body **14** connects together the leads in the corresponding one of the lead groups RA and RB. This portion is cut off after the resin molding process and before the completion of the product.

(Encapsulation Resin Body)

The encapsulation resin body **14** is provided by transfer molding so as to cover the internal structure including the die pads, IGBT **21** and HVIC **51** shown in FIG. 1. The encapsulation resin body **14** covers inner end portions of the plurality of leads, inverter circuit elements, converter circuit elements, brake circuit elements and integrated circuits enumerated above but does not cover outer end portions of the plurality of leads enumerated above. The material of encapsulation resin body **14** is a thermosetting resin.

Circuits in the First Embodiment

FIG. 2 is a circuit diagram of the semiconductor device **10** according to the first embodiment of the present invention. The same circuit elements as those shown in FIG. 1 are indicated by the same reference numerals.

The semiconductor device **10** has input terminals IN1, IN2, and IN3, which are connected to the converter circuit section CV.

The semiconductor device **10** has in the converter circuit section CV a circuit described below. The input terminal IN1 is connected to a connection point between the anode of the diode **41** and the cathode of the diode **44**. The input terminal IN2 is connected to a connection point between the anode of the diode **42** and the cathode of the diode **45**. The input terminal IN3 is connected to a connection point between the anode of the diode **43** and the cathode of the diode **46**.

The anodes of the diodes **44**, **45**, and **46** are electrically connected to each other and connected to a ground terminal

5

GND1. The cathodes of the diodes **41**, **42**, and **43** are electrically connected to each other and connected to a terminal A shown in FIG. 1.

In the brake circuit section BRK, the cathode of the diode **61** is connected to a terminal B shown in FIG. 2. The anode of the diode **61** is connected to the collector of the IGBT **62**. The collector of the IGBT **62** is connected to a ground terminal GND2.

The semiconductor device **10** has three arm circuits in the inverter circuit section INV. The first arm circuit is an arm formed by a series connection of the IGBT **21** and the IGBT **24**. The collector of the IGBT **21** is connected to the terminal B, which is electrically common to the cathode of the diode **61**. The emitter of the IGBT **21** is connected to the collector of the IGBT **24**. An output terminal OUT1 is connected to a connection point between the emitter of the IGBT **21** and the collector of the IGBT **24**.

The second arm circuit is an arm formed by a series connection of the IGBT **22** and the IGBT **25**. The collector of the IGBT **22** is also connected to the terminal B. The emitter of the IGBT **22** is connected to the collector of the IGBT **25**. An output terminal OUT2 is connected to a connection point between the emitter of the IGBT **22** and the collector of the IGBT **25**.

The third arm circuit is an arm formed by a series connection of the IGBT **23** and the IGBT **26**. The collector of the IGBT **23** is also connected to the terminal B. The emitter of the IGBT **23** is connected to the collector of the IGBT **26**. An output terminal OUT3 is connected to a connection point between the emitter of the IGBT **23** and the collector of the IGBT **26**.

The emitters of the IGBTs **24**, **25**, and **26** are connected to ground terminals GND3, GND4, and GND5, respectively.

The HVIC **51** can send control signals to gates G of the IGBTs **21**, **22**, and **23**, which are upper arms. The LVIC **52** can send control signals to gates G of the IGBTs **24**, **25**, and **26**, which are lower arms. Each of these control signals is ordinarily a PWM signal duty-ratio-controlled.

The LVIC **53** can send a control signal to a gate G of the IGBT **62** in the brake circuit section BRK.

In the present embodiment, as described above, a plurality of circuit elements and integrated circuits are mounted on a lead frame and encapsulated in a resin, and no insulating circuit board is used. Therefore, the assembly process is simplified and a low-priced package can be provided.

Since no control circuit board is used, the entire module can easily be reduced in size. The manufacturing cost can be reduced by avoiding use of a control circuit board, because an ordinary control circuit board itself is provided at a high cost. Printed-circuit boards (PCB boards) among control circuit boards have the drawback of being particularly low in moisture resistance. Lead frames made of metals are generally higher in moisture resistance than control circuit boards made, for example, by forming a wiring pattern on an insulating material.

While IGBTs are used in the present embodiment, MOSFETs may alternatively be used.

Second Embodiment

FIG. 3 is a top view showing a semiconductor device **210** according to a second embodiment of the present invention. In the top view of FIG. 3, however, a converter circuit section CV, a brake circuit section BRK, an inverter circuit section INV and an integrated control circuit section ICU are shown simply in circuit block form.

6

The internal constructions of the converter circuit section CV, brake circuit section BRK, inverter circuit section INV and integrated control circuit section ICU are the same as those in the semiconductor device **10** according to the first embodiment shown in FIG. 1. Die pads and leads of the semiconductor device **210** are not illustrated in FIG. 3. The construction of the die pads and leads of the semiconductor device **210** as seen in the top view is the same as that in the semiconductor device **10** according to the first embodiment.

The semiconductor device **210** has an encapsulation resin body **214** formed by transfer molding. The encapsulation resin body **214** has side surfaces **214c** and **214d** facing in opposite directions. The integrated control circuit section ICU is provided on the side surface **214c** side of a center of the encapsulation resin body **214**, while the converter circuit section CV, the brake circuit section BRK and the inverter circuit section INV are one-sidedly disposed on the side surface **214d** side by being arranged in a row. In this way, the integrated control circuit section ICU and the circuit sections (power sections) in which power semiconductor elements such as IGBTs are provided can be provided separately from each other.

The semiconductor device **210** has an insulating sheet **240**. The insulating sheet **240** has such an area as to extend over all the converter circuit section CV, the brake circuit section BRK and the inverter circuit section INV. The insulating sheet **240** does not reach the integrated control circuit section ICU. The insulating sheet **240** is made of an epoxy resin.

The insulating sheet **240** is in contact with back surfaces of die pads **102**, **104a**, **105a**, and **106a** belonging to the converter circuit section CV. The insulating sheet **240** is in contact with back surfaces of die pads **108a** and **109a** belonging to the brake circuit section BRK. The insulating sheet **240** is in contact with back surfaces of die pads **110a**, **111a**, and **112a** belonging to the inverter circuit section INV and a back surface of a die pad **209a** described below.

FIG. 4A is a sectional view of the semiconductor device **210** according to the second embodiment of the present invention, taken along line K-K in FIG. 3. In X-, Y-, and Z-axes shown in FIG. 4A, the Z-axis corresponds to the thickness direction of the semiconductor device **210**, and the X- and Y-axes correspond to plane directions of the semiconductor device **210**.

The semiconductor device **210** is the same as the semiconductor device **10** according to the first embodiment in having the lead **116** and the HVIC **51**. However, the semiconductor device **210** differs from the semiconductor device **10** according to the first embodiment in that the semiconductor device **210** has a lead **209**, the insulating sheet **240** and heat radiating copper foil **234**.

The semiconductor device **210** is packaged in the encapsulation resin body **214**. The encapsulation resin body **214** has an upper surface **214a**, a bottom surface **214b** and the side surfaces **214c** and **214d**, which are flat surfaces defining its external shape.

The lead **209** includes the die pad **209a**, a bent portion **209b** bent from the die pad **209a** in the thickness direction, and an outer lead portion **209c** that connects to the bent portion **209b**. The IGBT **21** and the freewheel diode **31** are die-bonded to the die pad **209a**. Wire bonding is also performed between the IGBT **21** and the freewheel diode **31**. With the bent portion **209b**, the die pad **209a** is stepped in the thickness direction.

The die pad **209a** and the die pad **116a** are shifted from each other in the thickness direction. The "thickness direction" denotes the direction of thickness of the die pad **209a** and the die pad **116a** corresponding to the Z-axis direction shown in FIG. 4A.

The heights of front surfaces of the die pad **209a** and the die pad **116a** as defined on the bottom surface **214b** of the encapsulation resin body **214** are as described below. The height of the front surface of the die pad **209a** is $h1$; the height of the front surface of the die pad **116a** is $h2$; and $h1 < h2$.

A step height S is created between the front surface of the die pad **209a** and the front surface of the die pad **116a**. FIG. 4B is an enlarged sectional view for explanation of the step height S . The step height S is $h3$.

The height from a front surface of the IGBT **21** to a back surface of the die pad **116a** is $h4$. Preferably, the height $h4$ is set large enough to reliably shield noise due to switching of the IGBT **21** with the die pad **116a**.

A back surface of the die pad **209a** is in contact with an upper surface of a stack structure formed by the insulating sheet **240** and the heat radiating copper foil **234**. The insulating sheet **240** is made of an epoxy resin having a high heat radiating property and an insulating property. The heat radiating copper foil **234** is thin copper foil having one surface on the bottom surface **214b** side exposed. The die pad **209a** is brought closer to the bottom surface **214b** relative to the die pad **116a**. Accordingly, the IGBT **21**, the freewheel diode **31** and other parts on the die pad **209a** are also disposed closer to the bottom surface **214b**.

The advantages of the present embodiment will be described. For ease of description, the IGBTs **21** to **26**, and **62**, the diodes **41** to **46**, and **61**, and the freewheel diodes **31** to **36** are referred to collectively as "IGBT **21** and other components" below.

When the HVIC **51** and the LVICs **52** and **53** are disposed in the IGBT **21** and other components, there is a possibility of noise generated with the operation of the IGBT **21** and other components (more specifically, the switching operation of the IGBTs) causing a malfunction in the HVIC **51** and the LVICs **52** and **53**.

The HVIC **51** and the LVICs **52** and **53** are required to be placed sufficiently away from the IGBT **21** and other components in order to avoid the influence of noise. If the HVIC **51** and the LVICs **52** and **53** are placed away from the IGBT **21** and other components along the plane directions, the size of the power module is increased.

In this regard, in the semiconductor device **210** according to the second embodiment, the step height S is provided between the HVIC **51** and LVICs **52** and **53** and the IGBT **21** and other components. The provision of the step height S enables the metal lead frames (that is die pads) on which the HVIC **51** and the LVICs **52** and **53** are mounted to serve as a shield. As a result, the HVIC **51** and the LVICs **52** and **53** cannot easily be influenced by noise caused by the operation of the IGBT **21** and other components.

Since the shielding function is provided by setting the step height S , the plane direction distance between the HVIC **51** and LVICs **52** and **53** and the IGBT **21** and other components (that is distance D in FIG. 4B) can be reduced. As a result, the plane direction size of the module can be reduced.

Since the IGBT **21** and other components are combined on the side surface **214d** side and arranged in a row, the provision of the insulating sheet **240** in rectangular form on the side surface **214d** side suffices. This arrangement enables reducing the necessary area of the insulating sheet **240** relative to

that in a case where the IGBT **21** and other components are artlessly disposed, thereby achieving a reduction in manufacturing cost.

Further, the sum of the thicknesses of the die pad **209a** and the stack structure formed by the insulating sheet **240** and the heat radiating copper foil **234** can be set to a small value. Therefore, heat generated by the IGBT **21** and other components can be transferred to the bottom surface **214b** side through a short path, thus ensuring good heat radiating performance.

In the second embodiment, the step height S is provided between the die pad **209a** and the die pad **116a**, as shown in FIG. 4A. However, the present invention is not limited to this.

Part or all of the die pads **102**, **104a**, **105a**, and **106a** belonging to the converter circuit section CV, the die pads **108a** and **109a** belonging to the brake circuit section BRK and the die pads **110a**, **111a**, and **112a** belonging to the inverter circuit INV in the first embodiment may be bent by providing bend portions **209b**, as is the die pad **209a**. Step heights S may be provided in this way between the die pads **116a**, **116b**, and **117a** and the die pads belonging to the converter circuit section CV, the brake circuit section BRK and the inverter circuit section INV.

The features and advantages of the present invention may be summarized as follows. According to the present invention, a semiconductor device has a converter circuit, a brake circuit and an inverter circuit, and the process of manufacturing the semiconductor device is simplified.

Obviously many modifications and variations of the present invention are possible in the light of the above teachings. It is therefore to be understood that within the scope of the appended claims the invention may be practiced otherwise than as specifically described.

The entire disclosure of Japanese Patent Application No. 2013-198812, filed on Sep. 25, 2013 including specification, claims, drawings and summary, on which the Convention priority of the present application is based, is incorporated herein by reference in its entirety.

What is claimed is:

1. A method of manufacturing a semiconductor device, the method comprising the steps of:
 - providing a single-plate lead frame made of one metal material, the single-plate lead frame including a plurality of die pads, a plurality of leads and an outer frame portion connected thereto;
 - mounting an inverter circuit element, a converter circuit element, a brake circuit element, and an integrated circuit mounted on the plurality of die pads;
 - connecting respectively, via wires, the plurality of leads to the inverter circuit element, the converter circuit element, the brake circuit element, and the integrated circuit;
 - encapsulating to provide an encapsulation resin body covering one end portions of the plurality of leads, the inverter circuit element, the converter circuit element, the brake circuit element and the integrated circuit, and not covering other end portions of the plurality of leads; and
 - lead-cutting the outer frame portion to form the plurality of leads separated each other.

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